

Work Order ID 67678

Tuesday, March 29, 2011 11:16:17 AM



Page 1

Item ID: D3197-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 3/29/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: MCDate: 4-03-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3197	Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

B.A 11/04/05

4 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Face ends to length per dwg D3197-2-Machine D3197-1 as per Folio FA340
and Dwg D3197-3-Deburr

B.A 11/04/05

4 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/04/05

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67678

Page 2

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Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Lathe Conv Conventional Lathe	CONVENTIONAL LATHE Memo Chamfer as per Dwg D3197	0.00 0.00		B.A 11/04/06		4	0		
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		sub 11/04/06		4	0		
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4		BR 11-4-6.	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Abstract

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00000000000000000000000000000000

Date:

**Insp.
Stamp**

SECRET

M 115138

Memo

1:40

3:20 ☐ FINISH TIME:

2.10

[REDACTED]

Memo

Quality Control

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

Memo

Small Fab

Assemble D3197-041 as per Dwg D3197

4 BL 11-4-6

48 All u/o x/oc

EP 11/04/18 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67678

Tuesday, March 29, 2011 11:16:17 AM



Page 4

Item ID: D3197-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 3/29/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

n/1 1 04 19 4

200

Identify as per dwg & Stock Location: 096

0.00



Packaging

Memo

0.00

Packaging

C4/4/19 (4)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/4/19 19

m/ 11-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Tuesday, March 29, 2011 11:16:40 AM






Page 1

[illegible]

Abstract

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev:B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24 		Purchased	No			100	Each	130.0000	2	8			
Screw													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST292				130					
					100151			130					
AN960JD10 	NAS1149D0363J	Purchased	No			180	Each	0.0000	6	24			
Washer													
D2690-5 		Manufactured	No			180	Each	19.0000	2	8			
Lanyard Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				19					
					66820			19					
D3242-1 		Manufactured	No			180	Each	12.0000	2	8			
Tag													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST044				12					
					65390			12					
D3489-3-200 		Manufactured	No			180	Each	5.0000	2	8			
PIP PIN													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST062				5					
					67042			5					

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

Tuesday, March 29, 2011 11:16:40 AM

Work Order ID: 67678

Parent Item: D3197-041

Parent Item Name: Bar Assembly

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 4.00

Required Qty: 4.00

M7075T73R1.000

Purchased

No

180

f

40.6150

2.42

12.1



7075-T73 Rd Bar 1.00

Location

Loc Qty

Loc Code

MAT012

40.615

115165

2.7

116405

4.54

116604

2.25

116835

12

✓116962

19.125

MS21042L3

Purchased

No

180

Each

2,189.000

2



Nut

Location

Loc Qty

Loc Code

ST300

2189

116391

589

116540

800

116549

800

9.7500 ft A.A 11/04/05

8
E.B. 11/04/18

8

Tuesday, March 29, 2011 11:16:40 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	67478
Description: Bar		Part Number:	D3197-1
Inspection Dwg: D3197	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.016	✓		Tape	GA-12
25.06	+/-0.030	25.076	✓		Tape	GA-12
11.44	+/-0.030	11.456	✓		Vern	CNC-02
0.500	+/-0.010	0.500	✓		Vern	GA-01
0.250	+/-0.030	0.266	✓		"	"
Ø0.219	+0.005/-0.000	Ø0.220	✓		"	"
Ø0.191	+0.005/-0.000	Ø0.193	✓		"	"
1.000	+/-0.005	0.999	✓		"	"
2.69	+/-0.030	2.690	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
0.300	+/-0.010	0.303	✓		"	"
0.063 x 45°	+/-0.010	0.065x45°	✓		"	"
Ø1.000	+/-0.010	0.999	✓		"	"

Measured by:	B.A	Audited by:	OML	Prototype Approval:	N/A
Date:	11/04/05	Date:	11/04/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM	BE

W/O:		WORK ORDER CHANGES					
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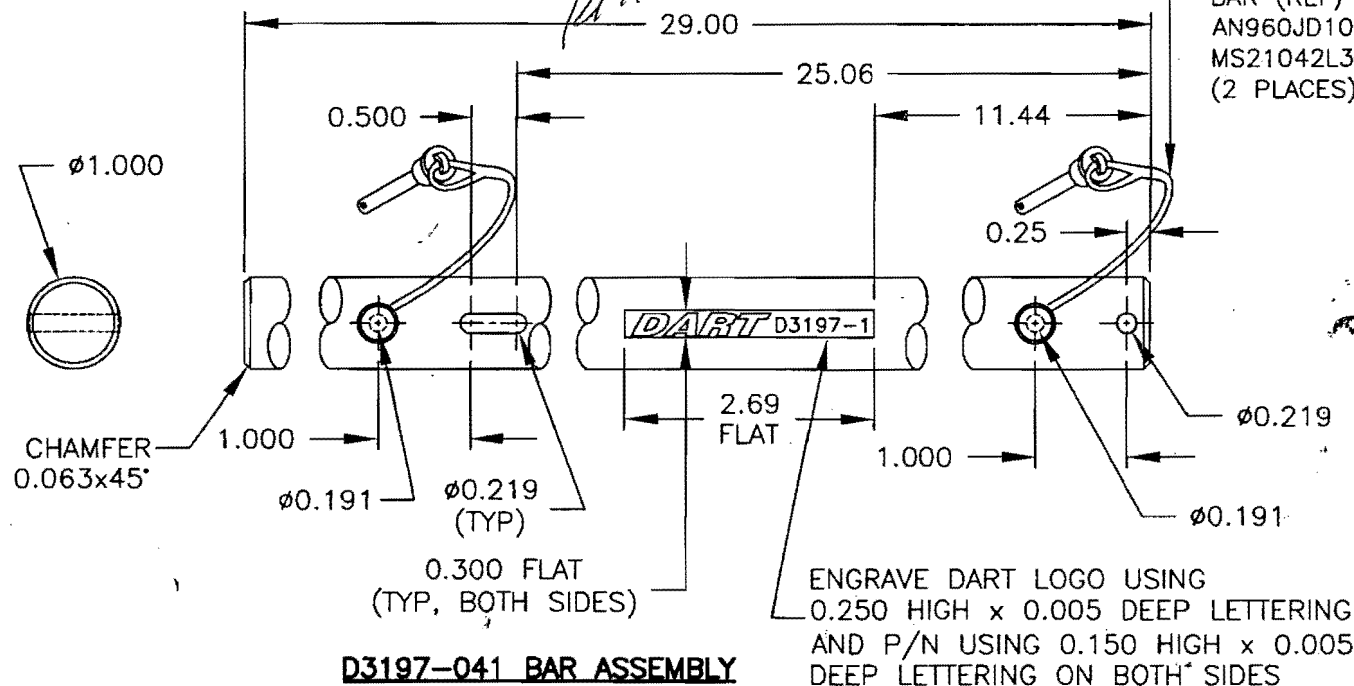
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 02678
11-03-28

RELEASED
00-03-21
11-03-28

D3489-3-200 PIP PIN (1)
D3242-1 TAG (1)
MS27039-1-24 BOLT (1)
AN960JD10 WASHER (1)
D2690-5 LANYARD (1)
AN960JD10 WASHER (1)
BAR (REF)
AN960JD10 WASHER (1)
MS21042L3 NUT (1)
(2 PLACES)



D3197-041 BAR ASSEMBLY

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	BAR	REV. B
		DRAWING NO.	D3197	SHEET 1 OF 1
		SCALE	1:1	
		DATE	03.07.01	
		NEW ISSUE		
		CHG PIP PIN; ADD D3242-1 TAG		

DART

W/O:		WORK ORDER CHANGES					
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